Work Ord September-27-12			25				*	908	2!	5 *							Page 1
Item ID: Revision ID: Item Name:	D350-607-511 Quick Release Basket Mounting Installa			lation	A	Accept		*N900040			100)* s	etup	Start Stop	171.	S1* S2*	
Start Date: Required Date: Reference:	9/27/12 11/09/12		Start Qty Req'd Qty			*1* *1*				Cust Item 1 Customer:	ID:						
Approvals:			: MLJ			2.40-0	Tooling SPC (Y				ate:		R	tun	Start Stop		R1* R2*
Sequence ID/ Work Center II	D		Operation Descriptio				Set I Run	Jp/ Hours		Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
Draw Nbr		Revis	ion Nbr														
D350-607-3		A			a A	3											
1 nn DC Document Control				Memo		labels per PPF	0.00 0.00 PD350-607	OAS 15 / -511 CHG002 /3 /1/24					H	4	ol N	<u>nus</u> 1	<u>2-11-</u> 2
*140 *140* Packaging Packaging		!	Pick Kit	Мето			0.00										12/11/20
150 *150* QC Quality Control		(inspect kits Memo	for completen	ess	0.00	OAS 15, / 12 11 24	á								

			DQA:	Date:	
ICR·	Yes / No	WORK ORDER NON-CONFORMANCE / LIPDATE			

											QA Closed:	Da	te:	
Work Ord	er:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS		
Part No						Rework Scrap Use-as-is Work Order Update	Th	Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Composite			-	Water Jet d. Eng. Coor. re/Packaging Supplier		Engineering Quality Other
Root	Description of work order update					Initia	1	Ac	ction	Sign &				
Cause		Date	Step	Qty		or Non-conformance	Chief E			cription	Date	Verificatio	n	QC Inspector
Doc/Data									-					
Equip/Tooling														
Operator														
Material		1												
Setup							l					ļ		
Other													İ	
Process							. A. C.	٠						
Supplier	Ш													
Training	Ш		i											
Unapproved														
		·				F	AULT CA	ATE	GORY					
Landi						General					_			
	—	ending				Bend	Gra				Ovalized		-	Pressure/Forced
	\vdash	entre No	t Concer	ntric to (D/S	BOM/Route	Hard	dwa	re		Over/Under	tolerance		Temperature/Cure
	\vdash	racks			<u> </u>	Broken/Damaged	⊢ '		on Incomplete		Part Incorre		-	Weld
		rushed/0	Crimped.		ļ	Burrs			ions Incomplete	/Unclear	Part Lost/Mi	issing		Wrong Stock Pulled
	Cuffs Contamination				4	⊢		nance		Part Moved				
	Heat Treat Countersink				Misl				Positioned V	_				
	Inspection Strip in Tube Cut Too Short				Misi		I	L	Power Loss/	Surge	Ш	Other		
Ripples in Bend Drill Holes				Offs										
	_	orque W		xtrusior	· _	Drawing	${f H}$		Calibration					· · · · · · · · · · · · · · · · · · ·
Turning Sequence Finish				Out	Out of Sequence									
	Wave/Twist in Tube				1 lout	cida	Dimensions							

Work Order ID 90825 *90825* September-27-12 1:52:14 PM D350-607-511 Item ID: Accept *N900040100* Setup Start Revision ID: Item Name: Ouick Release Basket Mounting Installation Start Date: 9/27/12 Start Oty: 1.00 **Cust Item ID:** Required Date: 11/09/12 Req'd Oty: 1.00 **Customer:** Reference: Start Run Process Plan: Approvals: Date: Tooling: Date: Stop Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Accept Reject Work Center ID Description Run Hours Code **Qty** Oty Number 160 0.00 *160* Packaging

170

QC21- Final Inspection - Work Order Release

Identify and pack for shipping as per PPP D350-607-511 Location:

0.00

0.00

170

OC

Packaging

Packaging

Quality Control

Memo

Memo

0.00

12/11/28 Syl

Insp.

Stamp

Page 2

			DQA:	Date:	
VCR.	Yes / No	WORK ORDER NON-CONFORMANCE / LIPDATE		_	

											QA Closed:	Date	:
Work Ord	er:					DISPOSITION				AGAINST DE	PARTMENT,	/PROCESS	
Part No. NCR No.						Rework Scrap Use-as-is Work Order Update		Thern	Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Composite			Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root	Т	Description of work order update						nitial					
Cause		Date	Step	Qty	B.	or Non-conformance		ief Eng		tion ription	Sign & Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling													
Operator													
Material	П			!		•							
Setup		-											
Other						,							
Process													
Supplier													,, *
Training													SC
Unapproved			!										
						F	AUL	T CATE	GORY				
Landi	ng G	ear				General	_				_	_	
	╚	Bending				Bend		Grain			Ovalized		Pressure/Forced
	Ц	Centre No	t Concer	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Цί	Cracks				Broken/Damaged	Ш	Inspecti	on Incomplete		Part Incorre	ct	Weld
	Ц	Crushed/0	Crimped.			Burrs	Ш	Instruct	ions Incomplete/	'Unclear	Part Lost/Mi	issing	Wrong Stock Pulled
	Cuffs Contamination				Contamination	Ш	Mainte	nance		Part Moved			
	Heat Treat Countersink					Mislabe	led		Positioned V	Vrong _	<u> </u>		
	Inspection Strip in Tube Cut Too Short					Misread	1		Power Loss/	Surge	Other		
	Ripples in Bend Drill Holes				Offset	-							
	Цī	Torque W	aves in E	xtrusio	n L	Drawing		Out of 0	Calibration				
	Turning Sequence Finish				Out of S	equence							
	LΙ	Mayo/Twist in Tubo				1 7	0	Dimensions					

Picklist Print

⇒ September-27-12 1:52:12 PM

Work Order ID:

90825

Parent Item:

D350-607-511

Parent Item Name:

Quick Release Basket Mounting Installation

Start Date: 9/27/12

Required Date: 11/09/12

Page 1

Start Qty: 1.00

Required Qty: 1.00

Cam	ments:	
V. (7)	mems:	

Comments:	IPP REV:A NEW	ISSUE 10-06-28 J	LM VE	RIFIED BY:	LL							
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measu		Qty per Kit	Total Qty	Qty Issued	Date Status Issued
D3910-3 Crosstube Lug		Manufactured	No			140	Each	68.0000	4	4	13	8/
540				Location		Loc Qty		Loc Code				
				ST464		68						
				876		36			876	.70		
				885	47	32						
D3984 Rubber Extrusion, Crossto	ube	Manufactured	No			140	f	173.4840	2	2	20	8
5	mS			Location		Loc Qty		Loc Code	•			
•	• • •			ST080		173.484						
				537	07	173.484			_5	3707		
D4148±041 Crosstube Lug Assembly,	Fwd	Manufactured	No			140	Each	8.0000	92	-715	78	
	~			Location		Loc Qty		Loc Code				
Sr	イン			ST468		8						
				857	52	2						
				875		4						
				880	47	2				<u> </u>		
D4149=041) Crosstube Lug Assembly,	Aft	Manufactured	No			140	Each	8.0000	1 9	27191	Jb_	12/1/205
\sim 1	<u></u>			Location		Loc Qty		Loc Code			•	
2M	し			FG460		8						
				875	69	8						

			DQA:	Date:	
NCR:	Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE		_	

									-		QA Closed:	Date	:		
Work Orde	er:					DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part No Rewo						Rework Scrap Use-as-is Work Order Update		Skid-tube Crosstube Water Jet Machining Small Fab Prod. Eng. Coor. Thermoforming Finishing Rec/Store/Packaging Large Fab Composite Supplier					Engineering Quality Other		
Root		 			Descri	ption of work order update	In	Initial Action			Sign &				
Cause		Date	Step	Qty	(or Non-conformance	Chie	ef Eng	Desc	cription	Date	Verification	QC Inspector		
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved										•					
				_		F	AULT	CATE	GORY		<u>, </u>				
Landii		Bending				General Bend		Grain	**		Ovalized	F	Pressure/Forced		
		Centre Not Concentric to O/S BOM/Route Cracks Broken/Damaged Crushed/Crimped Burrs Cuffs Contamination Heat Treat Countersink					Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance Mislabeled			Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V	Temperature/Cure Weld Wrong Stock Pulled				
	Inspection Strip in Tube Cut Too Short Drill Holes				Лisreac Offset	i		Power Loss/	· -	Other					
	Torque Waves in Extrusion Drawing Turning Sequence Finish Wave/Twist in Tube Folio				Out of S	Calibration Sequence Dimensions									

Picklist Print
September-27-12 1:52:13 PM

Work Order ID:	90825										
Parent Item:	D350-607-511							Star	Date: 9/27/12	Required Date	e: 11/09/12
Parent Item Name:	Quick Release Bas	ket Mounting Instal	lation			Star	t Qty: 1.00	Required Qty	Required Qty: 1.00		
ANY-19A Bolt		Purchased	No			140	Each	378.0000	123.	352 JB	5
				Locatio	<u>n</u>	Loc Oty		Loc Code		0	
Sm	<u></u>			FG		5			-		
$\supset_{\mathcal{U}_{\mathcal{V}}}$					122141	5					
				ST357		373					
					115374	1					
					120187	13			+		
					121068	17			*****		
					121708	4					
					122141	2					
					122800	250					
IS21042154			3.1-		123021	86					
ut		Purchased	No			140	Each	5,741.0000	16	16 JB	
				Locatio	<u>n</u>	Loc Oty		Loc Code		0 -	
5	Smb			314		2714					
_					122452	2714					
				ST300		27					
					119017	20				<u></u>	
					121444	7					
				ST314		3000					
					123021	3000			12302	<u>I</u>	
AS1149F0432P /asher		Purchased	No			140	Each	844.0000	32	32 35-22 JB	1211
				Locatio	<u>n</u>	Loc Qty		Loc Code		0	
	5ms			275		594					
					122441	594			8 × 1224	<u>41</u>	
				ST275		250			<u> </u>		
					121350	15					
					122151	235					

NCR:	Yes	/	No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA:	Date:	
	'	

WCN.	E3 / N				WORK ORDER WORK		VIANCE / OFE		QA Closed:	Date	:	
Work Order:					DISPOSITION		AGAINST DEPARTMENT/PROCESS					
Part No.					Scrap M		Skid-tube Crosstube Small Fab		Water Jet Prod. Eng. Coor.		Engineering Quality	
NCR No.					Use-as-is Work Order Update	Inerr	moforming Large Fab	Finishing Composite				
Root				Descr	iption of work order update	Initial	Acti	ion	Sign &			
Cause	Dat	e Step	Qty		or Non-conformance		Description		Date	Verification	QC Inspector	
Doc/Data								*				
quip/Tooling												
Operator			1 .									
//aterial												
etup						}	}					
Other	,											
Process			İ	-								
Supplier											•	
raining						:			2	·		
Jnapproved												
				_	F	AULT CATE	GORY					
Landir	ng Gear				General				_	· .		
	Bendi	ng			Bend	Grain			Ovalized		Pressure/Forced	
	Centre	Not Conc	entric to	o/s	BOM/Route	Hardwa	are		Over/Under	tolerance	Temperature/Cure	
	Cracks				Broken/Damaged	Inspect	ion Incomplete		Part Incorre	ct	Weld	
	Crushe	ed/Crimpe	i .		Burrs	Instruc	tions Incomplete/U	Inclear	Part Lost/Mi	ssing	Wrong Stock Pulled	
	Cuffs				Contamination	Mainte	enance		Part Moved			
	Heat T	reat			Countersink	Mislabe	eled		Positioned V	Vrong		
	Inspec	tion Strip i	n Tube		Cut Too Short	Misrea	d		Power Loss/	Surge	Other	
Inspection Strip in Tube Ripples in Bend			Drill Holes	Offset								
Torque Waves in Extrusion			Drawing	Out of	Out of Calibration							
[Turnin	g Sequenc	e		Finish	Out of	Sequence					
	Wave/Twist in Tube				Folio	Outside	e Dimensions					

REFERENCE ONLY 5W>

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D350-607-3 Page 17 of 19

4.0 WEIGHT AND BALANCE

Installation	Weight	LA	TERAL	LONGITUDINAL		
		Arm	Moment	Arm	Moment	
D350-607-541	80.7 lb	± 49.1 in	± 3962 in-lb	135 in	10895 in-lb	
(Standard Basket)	36.6 kg	± 1.25 m	± 45.8 m-kg	3.43 m	125.5 m-kg	
D350-607-543	65.7 lb	± 49.1 in	± 3226 in-lb	135 in	8870 in- l b	
(Lightweight Basket)	29.8 kg	± 1.25 m	± 37.3 m-kg	3.43 m	102.2 m-kg	
D350-607-545	58.7 lb	± 49.1 in	± 2882 in-lb	135 in	7925 in-lb	
(Standard Basket)	26.2 kg	± 1.25m	± 32.8 m-kg	3.43 m	89.9 m-kg	
D350-607-547	47.7 lb	± 49.1 in	± 2342 in-lb	135 in	6440 in-lb	
(Lightweight Basket)	21.6 kg	± 1.25 m	± 27.0 m-kg	3.43 m	74.1 m-kg	
D350-607-511 (Quick Release Basket Mounting Kit)	7.2 lb 3.3 kg	± 36.9 in ± 0.94 m	± 266 in-lb ± 3.1 m-kg	135 in 3.43 m	972 in-lb 11.3 m-kg	

5.0 PARTS LIST

QTY -541	QTY -543	QTY -545	QTY -547	QTY (-511)	QTY -501	PART NUMBER	DESCRIPTION
X						D350-607-541	HELI-UTILITY-BASKET
	Х					D350-607-543	HELI-UTILITY-BASKET
		X		1		D350-607-545	HELI-UTILITY-BASKET
			Х			D350-607-547	HELI-UTILITY-BASKET
1	1	1	1	X		D350-607-511	QUICK RELEASE BASKET MOUNTING KIT
					X	D350-607-501	CONVERSION KIT
						D0000 0	LANYARD
1	1	1	1		1	D2690-6	=X=TUBE:L:UG:
		<u> </u>		45	=4=	-D3910-3	EYEBOLT RECEIVER ASSY
1	1	1	1	-	1 .	D3912-041	RUBBER-EXTRUSIONX-TUBE
				<u>-</u> %=>∕	8	=D3984=030=====	LONG BASKET ASSY
1				ļ		D4030-041	LONG BASKET ASSY, LIGHTWEIGHT
	1					D4030-043	
		11		ļ		D4032-041	SHORT BASKET ASSY
			1			D4032-043	SHORT BASKET ASSY, LIGHTWEIGHT
1	1	11	1		1	D4085-3	PLACARD-INSTRUCTIONS
1					1	D4086-200	PLACARD, MAX LOAD
	1				1	D4086-215	PLACARD, MAX LOAD
		1			11	D4086-220	PLACARD, MAX LOAD
			1		1	D4086-232	PLACARD, MAX LOAD
					=1=	-D4148-041	FWD:X-TUBE-LUG ASSY
				₹1 ==	===	D4149-041	-AFT-X-TUBE-LUG-ASSY
1	1	1	11		1	D4150-041	-ATTACHMENT ARM ASSY
1	1	1	11		11	D4151-041	BASKET FWD HARDPOINT ASSY (LOWER)
1	11	1	1		1	D4151-043	BASKET FWD HARDPOINT ASSY (UPPER)
6	6	6	6		6	AN4-13A	BOLT
				-16 -	=16=	-AN4-14A	-BOLT
1	1	1	1		1	AN4C15	BOLT
1	1	1	1		1	AN310C4	CASTELLATED NUT
1 1	1	1	1		1	MS17984-C413	QUICK RELEASE PIN
6	6	6	6	16	=22=	MS21042L4	_NUT-(OR-MS21042-4)
1	1	Ť	1		1	MS24665-151	COTTER PIN
2	2	2	2		2	NAS1515H4L	WASHER
12	12	12	12	=32=	=44=	ENAS1449F0432P	WASHER
3	3	3	3		3	NAS1149C0463R	-WASHER

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Revision: A

Date: 10.06.28